

Work Order ID 75989

75989

Wednesday, November 02, 2011 1:16:30 PM

Ship New 7th or sooner Page 1

Item ID: D3137-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Guide
 Start Date: 11/3/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/7/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-11-02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3137	Rev F

100 BAND SAW 0.00
100
 Bandsaw Memo 0.00 ask 11/11/12 10 2
 Jeaspa Bandsaw Cut Blanks. Blank size: 1.250" x .750" x .950" long

110 HAAS CNC VERTICAL MACHINING #1 0.00
110
 HAAS 1 Memo 0.00 ask 11-11-13 (10)
 HAAS CNC vertical machine #1 I-Machine as per Folio FA242 & Dwg D31372-Deburr

120 QC2- Inspect parts off machine FAI/FAIB 0.00
120
 QC Memo 0.00 ask 11-11-13 10 2
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 11/7/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: ST 233B	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

11/11/15
 11-11-14
 10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 75989

Parent Item: D3137-3

Parent Item Name: Guide

Start Date: 11/3/2011

Required Date: 11/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A02.05.29New IssueNG
 IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC
 IPP Rev c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRLNB0.75X1.250 Delrin Bar		Purchased	No			100	f	31.9328	0.0791	0.8326316			

Location	Loc Qty	Loc Code
MAT055	31.9328	
117985	0.5328	
→ 118066	7	
119133	24	
14535	0.4	

184 out 11/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

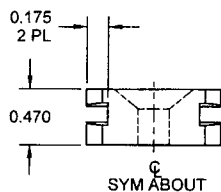
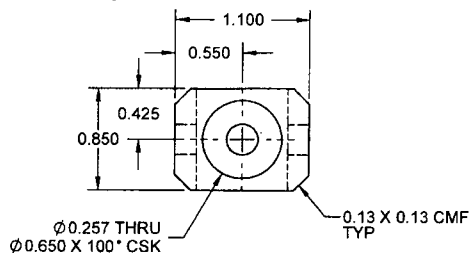
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

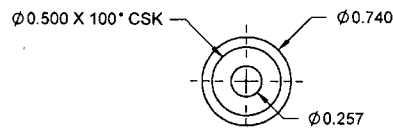
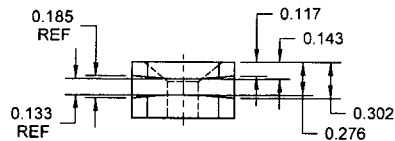
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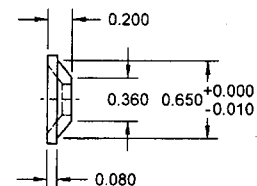
8 7 6 5 4 3 2 1



D3137-3 GUIDE



D3137-5 WASHER



Handwritten: #35989

NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL, BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	J.AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3137	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	08.05.30	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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